

162266

Page 1

N900040100

Setup Start *NS1*

Stop ***NS2***

10

10

Run Start *NR1*

Date: _____

Date:

Date:

Stop *NR2*

**Insp.
Stamp**

ack kt 10

DAS
6
9-89

JUN 01 2017

10 DAS 27 9-99 JUN 05 2017

10 JUN 05 2017

Quality Control

DAS
38
9-89

~~JUN 05 2017~~

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Date :		Step #:		QTY Effective :			MRB (QSI042) Approval																		
Description Work Order Deviation				Disposition				Completed By																	
								Lead hand / Supervisor Approval Verification																	
								QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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OTHER :																									

Work Order ID 162266***162266***

Page 2

Wednesday, May 31, 2017 9:59:31 AM

Item ID: D350-615-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: GHW Modification, Fits LH or RH

Start Date: 5/31/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/12/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC4- 100% Inspect kits for completeness

0.00

130

QC

Memo

0.30

Quality Control

10 DAS
27
9-89
JUN 05 2017

140

Identify as per dwg & Stock Location: _____

0.00

140

Packaging

Memo

0.00

Packaging

Identify with Eurocopter and Dart part# using permanent ink stamp and pack for shipping as per PPP D350-615-041
Location : FG02310 DAS
27
9-89
JUN 05 2017

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

1.00

Quality Control

17/6/17

JUN 06 2017

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER :									

Picklist Print

Wednesday, May 31, 2017 9:59:36 AM

Page 1

Work Order ID: 162266

162266

Parent Item: D350-615-041

D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

Start Date: 5/31/2017

Required Date: 6/12/2017

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:K Removed Manufacturing 05-12-05 JLM IPP Rev:L
revise bom DD 10.03.18 verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2282-041 *D2282-041* T Assembly		Manufactured	No			110	Each	12.0000	1	10		JUN 05 2017	DAS 19 9-89

Location Loc Qty Loc Code

GA 12

161266 12

D2282-043 *D2282-043* Saddle Assembly		Manufactured	No			110	Each	0.0000	1	10		JUN 05 2017	DAS 19 9-89
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Location Loc Qty Loc Code

ST583 54

m137100 54

5/16-18-015C *5/16-18-015C* SS Bolt 5/16-181.5"		Purchased	No			110	Each	54.0000	3	30		JUN 01 2017	DAS 6 9-89
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Location Loc Qty Loc Code

ST583 54

m137100 54

D3015-3 *D3015-3* Locknut		Manufactured	No			110	Each	50.0000	3	30		JUN 01 2017	DAS 6 9-89
---------------------------------	--	--------------	----	--	--	-----	------	---------	---	----	--	-------------	------------------

Location Loc Qty Loc Code

FG 18

95758 8

96151 10

ST015 32

158471 32

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
Root Cause		FAULT CATEGORY							
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Finishing ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐				
OTHER : ☐									

Picklist Print

Wednesday, May 31, 2017 9:59:36 AM

Page 2

Work Order ID: 162266

Parent Item: D350-615-041

Parent Item Name: GHW Modification, Fits LH or RH

162266

D350-615-041

Start Date: 5/31/2017

Required Date: 6/12/2017

Start Qty: 10.00

Required Qty: 10.00

5/16WC Purchased No 110 Each 195.0000 12 120

5/16WC

Washer

**

Location

Loc Qty

Loc Code

ST583

173

m137324

173

WA001

22

m136525

22

DAS
6
9-89

JUN 01 2017

120

7/16-14-050C Purchased No 110 Each 10.0000 1 10

7/16-14-050C

SS Bolt 7/16 5" Long

**

Location

Loc Qty

Loc Code

ST584

10

m136525

10

DAS
6
9-89

JUN 01 2017

10

D3015-5 Manufactured No 110 Each 40.0000 1 10

D3015-5

SS Nylock Nut 7/16

**

Location

Loc Qty

Loc Code

ST015

40

160671

40

DAS
6
9-89

JUN 01 2017

10

7/16WC Purchased No 110 Each 395.0000 2 20

7/16WC

Washer, SS Flat 7/16

**

Location

Loc Qty

Loc Code

ST5584

78

M137547

78

ST584

317

M137581

317

DAS
6
9-89

JUN 01 2017

20

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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OTHER : _____																									

Work Order ID 162266

162266

Page 1

Wednesday, May 31, 2017 9:59:31 AM

Item ID: D350-615-041

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: GHW Modification, Fits LH or RH

Start Date: 5/31/2017 Start Qty: 10.00

10

Cust Item ID:

Required Date: 6/12/2017 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: _____ Date: MAY 31 2017 Tooling: _____ Date: _____
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D350-615-041

B

100

Document Control

0.00 MAY 31 2017

100

DC

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile and type labels with Eurocopter part# (2 GHW Kits per box)
 as per PPP D350-615-041 CHG003

CB

JUN 05 2017

110

0.00

110

Small Fab

Memo

0.27

Small Fab

Assemble D2282-041 with D2282-043 as per Dwg D350-615 ***Only engage
 one thread on three 5/16-18-015C bolts***

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.20

Quality Control

DT